

Work Order ID 86574

July-05-12 11:14:30 AM

86574

Page 1

Item ID: D3769-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 7/05/12 Start Qty: 10.00

10

Cust Item ID:

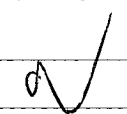
Required Date: 7/13/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3769

Rev A

100

0.00

100

Small Fab


Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D37692-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig3- deburr

10 

FF 12-07-05

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

Encl 07/06

10 10 12-07-06

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

10 26 12-7-9

Work Order ID 86574***86574***

Page 2

July-05-12 11:14:30 AM

Item ID: D3769-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 7/05/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/13/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

100 12/2/10 SD

140

Identify as per dwg & Stock Location: **251A**

0.00

140

Packaging

Memo

0.00

Packaging

100 12/7/10 SD

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

OK 12/7/10MF
12-07-10

Picklist Print

July-05-12 11:14:30 AM

Page 1

Work Order ID: 86574

Parent Item: D3769-5

Parent Item Name: Tube

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065 6061T6 RD TUBE 1.00 x .065w		Purchased	No			100	f	52.4044	1.6742	17.623158			

10 FF 12-07-05

Location	Loc Qty	Loc Code
MAT015	52.4044369	
114089	0.3114	
116720	1.2	
117983	24.4351469	
122146	26.45789	

14.878526
3.651111

8

7

6

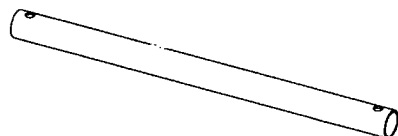
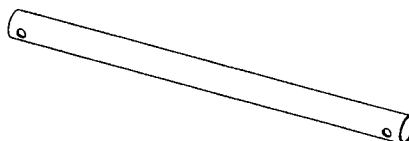
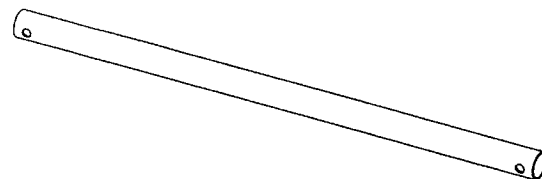
5

4

3

2

1

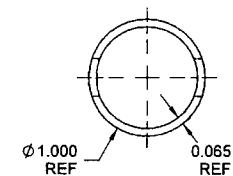
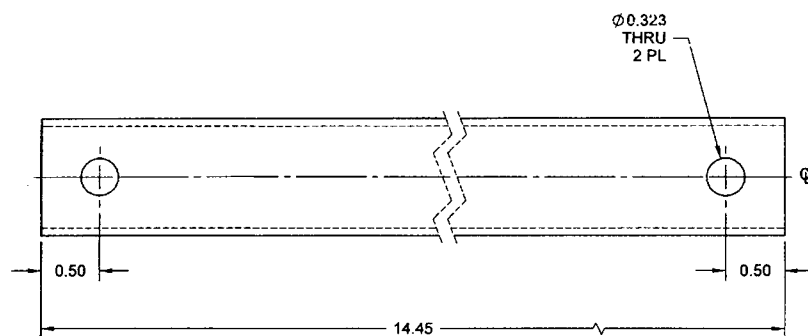
**D3769-1 TUBE****D3769-3 TUBE****D3769-5 TUBE**

RELEASED
08-06-15

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

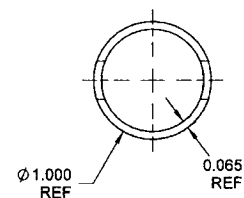
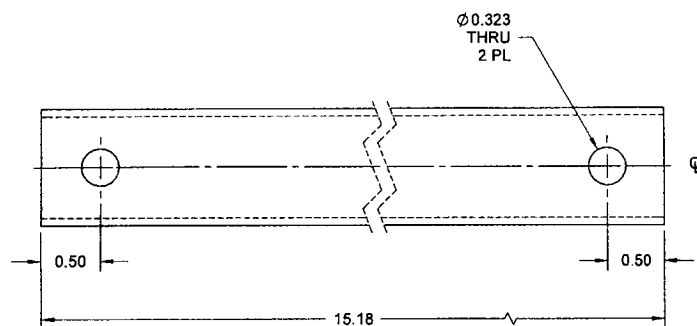
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3769 REV. A SHEET 1 OF 4 TITLE TUBE SCALE NTS DATE 08.06.04	
DRAWN	HS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3769-1 TUBE

RELEASED

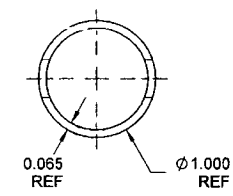
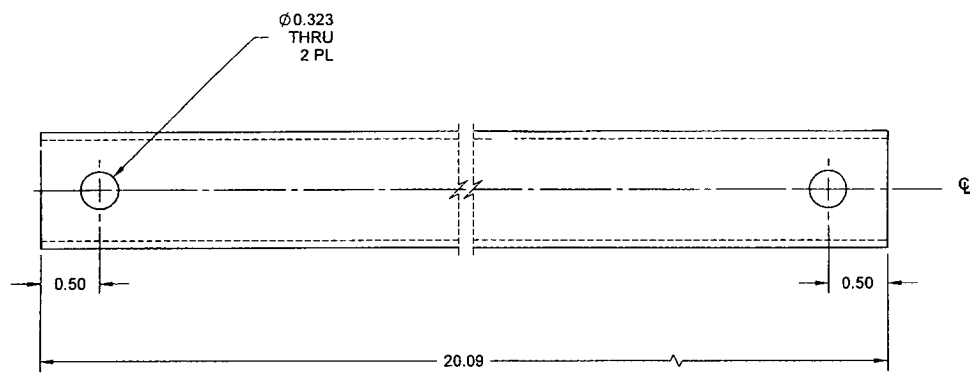
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>HS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>HS</i>	D3769	SHEET 2 OF 4
APPROVED	<i>HS</i>	TITLE	SCALE
DE APPR.	<i>HS</i>	TUBE	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3769-3 TUBE

RELEASED
08-06-14/17

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>HS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>HS</i>	D3769	SHEET 3 OF 4
APPROVED	<i>HS</i>	TITLE	SCALE
DE APPR.	<i>HS</i>	TUBE	NTS
DATE	08.06.04	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3769-5 TUBE

RELEASED
08-06-16

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	